



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

SWA6A-2 Job Sheet 189352



Part No: SWA6A-2

Job Qty: 1 pcs

Part Name: Electric Swivel 6,000 lb Safe Work Load (2,721 Kg)



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/23/19

Job Tracking No:

Due Date: 2/20/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG SWA6A-2 Rev4 IPP Rev A 17.11.15 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	External Load - 1	1 pcs	2/20/19		0.00	0.00	External Load - 1		AP
							External Load - 2		
							External Load - 3		
110	External Load - 2 - B4B	1 pcs	2/20/19		0.00	2.00	External Load - 1 - B4B		Michel AP 2019/03/12
							External Load - 2 - B4B		
							External Load - 3 - B4B		
120	QC 5	1 pcs	2/20/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 42		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
125	DC - 1 - B4B	1 pcs	2/20/19		0.00	0.00	QC 5 - 50		DAS 30 9-89
							QC 5 - 30		
							DC - 1 - B4B		
130	Packaging 3-1 - Stock - B4B	1 pcs	2/20/19		0.00	0.00	DC - 2 - B4B		
							Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		
130	Packaging 3-6 - B4B						Packaging 3 - 6 - B4B		



Dart Aerospace Ltd.
1270 Aberdeen Street
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CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S161254



Part: SWA6A-2

Job No: 189352

Serial No/Batch: S161254

Revision: E

Inspector:

Exp Date:

Instructions:

Date: 03/11/19

Plex 2/8/19 8:50 AM Dart.Hadley.Shannon

				Packaging 3 - 7 - B4B	DAS
				Packaging 3 - 8 - B4B	30
				Packaging 3 - 9 - B4B	9-89
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
140	QC 21 - FG	1 pcs	2/20/19	0.00 0.00	QC 21 - FG - 21
					QC 21 - FG - 70
					QC 21 - FG - 53

Part Op **90** - -Assemble as per DWG. Sheet 1 ***All assembly to be done in accordance with SWA swivel manual*** Engrave T/N
 Descriptions: And / or S/N number as required Using Marktronic engraver as per DWG. Laser engrave dart logo as per DWG.
110 - -Assemble as per DWG. Sheet 1 ***All assembly to be done in accordance with SWA swivel manual*** Engrave T/N
 And / or S/N number as required Using Marktronic engraver as per DWG. Laser engrave dart logo as per DWG.
120 - (QC5- Inspect part completeness to step on W/O) Engrave T/N And / or S/N number as required Using Marktronic engraver as per DWG.
125 - (Document Control) Photocopy blue file OM & OOPM-SWA6A Rev2
130 - (Identify as per dwg & Stock Location: _____) Bag and tag
140 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
SWA6A-800A	Connector Bushing	1 pcs (1 ea)	90-External Load - 1	5029419
188-FPSS-1032-5/8	Set Screw	1 Ea (1 ea)	110-External Load - 2 - B4B	5037083
188-FSCS-1032-5/8	Set Screw	4 Ea (4 ea)	110-External Load - 2 - B4B	5078378
C45-15-13	Bushing for SWA6A	1 Ea (1 ea)	110-External Load - 2 - B4B	5089116
EL-PLUG-F	3-Prong Female Spade Plug	1 Ea (1 ea)	110-External Load - 2 - B4B	5054450
EL-PLUG-M	3-Prong Male Spade Plug	1 Ea (1 ea)	110-External Load - 2 - B4B	5054451
EL314-SJTOW	Long Line Electrical Wire, 14/3 Gauge	6 ft (6 ea)	110-External Load - 2 - B4B	5047767
SWA6A-100	Lower End	1 pcs (1 ea)	110-External Load - 2 - B4B	5159346
SWA6A-1100	Upper Bearing	1 pcs (1 ea)	110-External Load - 2 - B4B	5128642
SWA6A-1200	Lower DU Bearing	1 Ea (1 ea)	110-External Load - 2 - B4B	5156228
SWA6A-1300	Lower Thrust Bearing	1 Ea (1 ea)	110-External Load - 2 - B4B	5141320
SWA6A-1400	Circlip Internal	1 Ea (1 ea)	110-External Load - 2 - B4B	5045017
SWA6A-1800	Cover	1 pcs (1 ea)	110-External Load - 2 - B4B	5098582
SWA6A-1900	1/4" Female Spade Connector	4 Ea (4 ea)	110-External Load - 2 - B4B	5027243
SWA6A-200	Upper End	1 pcs (1 ea)	110-External Load - 2 - B4B	5161312
SWA6A-300	Bearing Housing	1 pcs (1 ea)	110-External Load - 2 - B4B	5161306
SWA6A-400	Thrust Washer	1 pcs (1 ea)	110-External Load - 2 - B4B	5133694
SWA6A-500 P	Semi Rings	1 pcs (1 ea)	110-External Load - 2 - B4B	5029414
SWA6A-600	Collar	1 pcs (1 ea)	110-External Load - 2 - B4B	5034731
SWA6A-700	Wire Clamp	2 pcs (2 ea)	110-External Load - 2 - B4B	5155660
SWA6A-900A	Rotary Connector - 2 wire	1 pcs (1 ea)	110-External Load - 2 - B4B	5108022
GREASE AEROSHELL NO.7 (M138724) SILCOGE (M138994)				
LOCTITE 242 (M138766) LOCTITE 620 (M138933)				
SAF-T-EZE (M128063)				

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-External Load - 1	SWA6A-800A	1	13	0
110-External Load - 2 - B4B	188-FPSS-1032-5/8	1	281	0
	188-FSCS-1032-5/8	4	154	0
	C45-15-13	1	21	0
	EL-PLUG-F	1	31	0
	EL-PLUG-M	1	35	0
	EL314-SJTOW	6	598	0
	SWA6A-100	1	2	0
	SWA6A-1100	1	28	0
	SWA6A-1200	1	12	0
	SWA6A-1300	1	15	0
	SWA6A-1400	1	19	0
	SWA6A-1800	1	12	0
	SWA6A-1900	4	323	0
	SWA6A-200	1	5	0
	SWA6A-300	1	7	0
	SWA6A-400	1	8	0
	SWA6A-500	1	0	0
	SWA6A-600	1	12	0
	SWA6A-700	2	15	0
	SWA6A-900A	1	18	0

Part Specifications

Specifications could not be found.

Plex 2/8/19 8:50 AM Dart.Hadley.Shannon



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Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		2/20/19	0.00	0.00	Start Up Small Fab-2		
110	Small Fab	1 pcs		2/20/19	0.00	2.00	Small Fab-6		
120	QC	1 pcs		2/20/19	0.00	0.00	QC5		
125	DC	1 pcs		2/20/19	0.00	0.00	DC		
130	Packaging	1 pcs		2/20/19	0.00	0.00	Packaging3		
140	QC21-FG	1 Ea		2/20/19	0.00	0.00	QC21		

Part Op 110 - Assemble as per DWG. Sheet 1 ***All assembly to be done in accordance with SWA swivel manual*** Engrave T/N Descriptions: And / or S/N number as required Using Marktronic engraver as per DWG. Laser engrave dart logo as per DWG.

120 - Engrave T/N And / or S/N number as required Using Marktronic engraver as per DWG.

125 - Photocopy blue file OM & OOPM-SWA6A Rev2

130 - Bag and tag

Job BOM

Part / Item	Component Name	Quantity	Operation	Container	
SWA6A-800A	Connector Bushing	1 pcs (1 ea)	90-Start up Operation	5044846	5029419
188-FPSS-1032-5/8	Set Screw	1 Ea (1 ea)	110-Small Fab	5037083	
188-FSCS-1032-5/8	Set Screw	4 Ea (4 ea)	110-Small Fab	5078378	
C45-15-13	Bushing for SWA6A	1 Ea (1 ea)	110-Small Fab	5089116	
EL-PLUG-F	3-Prong Female Spade Plug	1 Ea (1 ea)	110-Small Fab	5054450	
EL-PLUG-M	3-Prong Male Spade Plug	1 Ea (1 ea)	110-Small Fab	5054451	
EL314-SJTOW	Long Line Electrical Wire, 14/3 Gauge	6 ft (6 ea)	110-Small Fab	5047767	
N SWA6A-100	Lower End	1 pcs (1 ea)	110-Small Fab	5148353	159346
SWA6A-1100	Upper Bearing	1 pcs (1 ea)	110-Small Fab	5128642	
SWA6A-1200	Lower DU Bearing	1 Ea (1 ea)	110-Small Fab	5044605	5156228
SWA6A-1300	Lower Thrust Bearing	1 Ea (1 ea)	110-Small Fab	5141320	
SWA6A-1400	Circlip Internal	1 Ea (1 ea)	110-Small Fab	5045017	
SWA6A-1800	Cover	1 pcs (1 ea)	110-Small Fab	5098582	
SWA6A-1900	1/4" Female Spade Connector	4 Ea (4 ea)	110-Small Fab	5047603	5027213
N SWA6A-200	Upper End	1 pcs (1 ea)	110-Small Fab	5149089	148353
SWA6A-300	Bearing Housing	1 pcs (1 ea)	110-Small Fab	5101948	5161306
SWA6A-400	Thrust Washer	1 pcs (1 ea)	110-Small Fab	5133694	5156228
SWA6A-500	Semi Rings	1 pcs (1 ea)	110-Small Fab	5029414	
SWA6A-600	Collar	1 pcs (1 ea)	110-Small Fab	5034731	
SWA6A-700	Wire Clamp	2 pcs (2 ea)	110-Small Fab	5155660	
SWA6A-900A	Rotary Connector - 2 wire	1 pcs (1 ea)	110-Small Fab	5126634	5108022

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	SWA6A-800A	1	13	0
110-Small Fab	188-FPSS-1032-5/8	1	185	0
	188-FSCS-1032-5/8	4	154	0
	C45-15-13	1	21	0
	EL-PLUG-F	1	22	0
	EL-PLUG-M	1	36	0
	EL314-SJTOW	6	367	0
	SWA6A-100	1	1	0
	SWA6A-1100	1	28	0
	SWA6A-1200	1	12	0
	SWA6A-1300	1	15	0
	SWA6A-1400	1	19	0
	SWA6A-1800	1	12	0
	SWA6A-1900	4	339	0
	SWA6A-200	1	2	0
	SWA6A-300	1	7	0
	SWA6A-400	1	8	0
	SWA6A-500	1	0	0
	SWA6A-600	1	1	0
	SWA6A-700	2	15	0
	SWA6A-900A	1	9	0

Part Specifications

Specifications could not be found.

Plex 1/23/19 8:28 AM Dart.lajeunesse.marie

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread		Other/Details:			

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: <u>189352</u> Part No. <u>SWA### Swivels</u> NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																							
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Date : <u>2019 / 03 / 12</u>		Step #: _____		QTY Effective : _____		MRB (QSI042) Approval Feb 01, 2018																																																																									
Description Work Order Deviation				Disposition																																																																											
- Use a combination of heatshrink tubing and RTV Silicone to create a watertight seal around all electrical connections. - Use a D2728-1 Placard in place of the laser engraved Dart logo				These deviations are acceptable to carry out on the following swivels: - SWA3 - SWA6A - SWA10A - SWA15A - SWA25A - PSWA25A There is no impact on fit, form or function.				Completed By <u>A. PATRY</u>																																																																							
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Work Order 189352

Customer 13113

Number of Wires 2

Date 2019-3-12

Serial Number 5161254

Number of Cycles	Load (Lbs.)	Action	Pass/Fail
1	6,000	Check for Conductivity against all wires.	- Pass
1	6,000	Check all wires for grounding against swivel body.	- Pass
1	3,000	Check for Conductivity against all wires.	- Pass
1	3,000	Check all wires for grounding against swivel body.	- Pass
1	1,500	Check for Conductivity against all wires.	- Pass
1	1,500	Check all wires for grounding against swivel body.	- Pass
1	0	Check for Conductivity against all wires.	- Pass
1	0	Check all wires for grounding against swivel body.	- Pass

Test Conducted By: Michel Lalonde

Technician

Signature: Sylvie Boucher
QC-5 Small FAB / QA

Submit